



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4463-9

Job Sheet 169551



Part No: D4463-9

Job Qty: 2 ea

Part Name: Tank Back



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D SHEETS 9,10 IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC IPP REV:B 13.10.28 DWG REV PD1 DD VERF:JLM IPP REV:C 14.06.13 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Waterjet		SC 17/12/20
100	Waterjet	2 pcs	1/18/18	1/18/18	0.00	0.63	Waterjet1		SC 17/12/20
110	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC2 Waterjet-3		SC 17/12/20
120	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC8-4		38
130	Brake NC	2 pcs	1/18/18	1/18/18	0.11	0.47	Brake NC 2		38
140	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC6		38
150	HandFinish	2 pcs	1/19/18	1/19/18	0.00	0.38	HandFinish1		2018/01/15 JSL
160	QC	2 pcs	1/19/18	1/19/18	0.00	0.00	QC7-3		38
170	Packaging	2 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-2		WABO3 BEB 18/01/17
180	QC21-SA	2 Ea	1/19/18	1/19/18	0.00	0.00	QC21		21

JAN 18 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063	28	391	0	0

5013852

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order Deviation																																																									
Job No: 169551 Mtg Date: 12/23/17 Start up Operation D4463 - 9 PART NO: _____ Revision: _____ Operation: _____ Change No: _____ Tank Back Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																									
Completed By																																																									
Lead hand / Supervisor Approval Verification																																																									
QC / QA Coordinator Approval																																																									
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> </table>						Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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Pr ☐ Be ☐ Ce ☐ Cri ☐ Cri ☐ Cut ☐ Cru ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																																									
OTHER : _____																																																									

DART AEROSPACE LTD		Work Order:	169551
Description: tank back		Part Number:	4463-9
Inspection Dwg: 4463		Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43,21	+/- 0,030	43,21	1		VRC or	
23,99	+/- 0,030	23,99	1		Tape	
33,20	+/- 0,030	33,20	1			
5,16	+/- 0,030	5,162	1			
1,57	+/- 0,030	1,578	1			
17,19	+/- 0,030	17,19	1			
1,60	+/- 0,030	1,60	1			
2,20	+/- 0,030	2,201	1			
Ø 0,128	+0,005-0,001	Ø 0,128	1			
26,22	+/- 0,030	26,22	1			
12,10	+/- 0,030	12,10	1			
0,750	+/- 0,010	0,752	1			
0,375	+/- 0,010	0,377	1			
4,70	+/- 0,030	4,70	1			
0,660	+/- 0,010	0,665	1			
0,063	+/- 0,010	0,063	1			

Measured by: SC	Audited by: DAS 38	Preliminary Approval:
Date: 17/12/20	Date: DEC 28 2017	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	